

What is claimed is:

1. A laser welding head-controlling system comprising:  
a laser irradiating body with a laser inlet and a laser outlet,  
plural semiconductor lasers to oscillate plural linear laser beams for  
measuring a welding state,  
a CCD camera with a band-pass filter therein to pass through only the  
reflected linear laser beams to take in, as an image, the measured welding  
state by the reflected linear laser beams, and  
an image processor to process the image of the measured welding state.
2. A laser welding head comprising a laser welding head-controlling  
system as defined in claim 1, a laser oscillator to oscillate a laser for welding  
and a condenser to converge the oscillated laser.
3. A method for controlling a laser welding head comprising the steps  
of:  
irradiating plural linear laser beams for parts to be welded of members  
to be welded to measure a welding state from plural semiconductor lasers,  
taking, as an image, the measured welding state by the reflected linear  
laser beams into a CCD camera,  
processing the image of the measured welding state, and  
controlling a laser welding head based on the processed data of the  
image.
4. A method for controlling a laser welding head as defined in claim  
3, wherein the laser welding head is controlled by the CAD data of the parts  
to be welded.
5. A method for controlling a laser welding head as defined in claim  
3 or 4, further comprising the step of monitoring welding defects of the parts  
to be welded based on the processed data and the CAD data.